

**Work Order ID 71068**

Tuesday, June 21, 2011 2:33:55 PM

Page 1

Item ID: D4017-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Short Basket Base Assembly (350 )

Start Date: 6/21/2011 Start Qty: 1.00

Required Date: 6/30/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4017

C

100

Weld per dwg A/R S.S. rod Batch: *M115778* 0.00

Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble ribs , weld as per dwg D4017 using DT9610B  
\*\*\*inspect before welding mesh\*\*\*  
2- tack weld mesh on basket as per dwg D4017 and trim mesh to fit if necessary  
and trim to clear fasteners holes on the ends  
3- weld hinge (3) and Mounting brackets as per dwg D4017  
\*\*\*take lid to locate hinge and bracket\*\*\*

*11.06.24*

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

*11.06.27*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Customer:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

125

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

IX Ø m-l 4/06/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Required Date:	6/30/2011	Req'd Qty:	1.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
	Memo	0.00							
	1- Plug holes and mask only interior of hinge (3) prior to powder coat								
	1ST COAT:								
	START TIME: 10:50								
	OVEN TEMPERATURE: 400 OF								
	FINISH TIME: 11:20								
	***** 2nd coat if necessary *****								
	2ND COAT:								
	START TIME:								
	OVEN TEMPERATURE:								
	FINISH TIME:								
140  QC Quality Control	QC3- Inspect Part Finish	0.00							
	Memo	0.00							

IX Ø M-14/06/28

1 Ø BL 11-6-28

M117745

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Required Date: 6/30/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150



HandFinish

Assemble as per dwg

0.00

Memo

0.00

Hand Finishing

EP 11/06/28 (2)

160



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

S 11/06/28



170



Packaging

Identify as per dwg &amp; Stock Location: G.A

0.00

Memo

0.00

Packaging

W/071067

EP 11/06/28

W/O:		WORK ORDER CHANGES					
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Required Date: 6/30/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/29

MF

11-06-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 1

Work Order ID: 71068

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350 )




Start Date: 6/21/2011

Required Date: 6/30/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC  
per dwg RevA DD 10.03.06 verified by:EC  
DD 10.04.16 verified by:EC  
verified by:EC  
IPP Rev:B as per dwg RevB  
IPP Rev:C as per dwg RevB  
IPP Rev:D as per dwg revC DD 10.08.18  
IPP Rev:E 10.11.04 added pressure wash DD  
verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4017-1  Rib		Manufactured	No			100	Each	6.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>WA006</div> <div>6</div> <div></div> </div>													
<div> <div>68394</div> <div>3</div> <div></div> </div>													
<div> <div>68481</div> <div>3</div> <div></div> </div>													
D4018-1  Rib		Manufactured	No				Each	7.0000		1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>WA</div> <div>2</div> <div></div> </div>													
<div> <div>67039</div> <div>2</div> <div></div> </div>													
<div> <div>WA005</div> <div>5</div> <div></div> </div>													
<div> <div>68478</div> <div>3</div> <div></div> </div>													
<div> <div>69077</div> <div>2</div> <div></div> </div>													
****D4018-1 is the same as D4017-3***													
D4017-5  Hinge Rib		Manufactured	No			100	Each	3.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>WA</div> <div>3</div> <div></div> </div>													
<div> <div>68480</div> <div>3</div> <div></div> </div>													

SAD 11-06-22

SAD 11-06-22

SAD 11-06-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 2

Work Order ID: 71068

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350 )

Start Date: 6/21/2011

Required Date: 6/30/2011

Start Qty: 1.00

Required Qty: 1.00

D4017-7 Manufactured No

100

Each

0.0000

1

1



Rib

BG9730 x1



SAD 11-06-22

D4017-9 Manufactured No

100

Each

8.0000

2

2



Rib



SAD 11-06-22

## Location

## Loc Qty

## Loc Code

WA

8

69011

2

70341

6

2

D3916-041 Manufactured No

100

Each

2.0000

2

2



Rib Assembly



SAD 11-06-22

## Location

## Loc Qty

## Loc Code

WA

2

69010

2

D3916-5 Manufactured No

100

Each

9.0000

1

1



Light Rib



SAD 11-06-22

## Location

## Loc Qty

## Loc Code

WA

9

59088

9

D4034-041 Manufactured No

100

Each

5.0000

1

1



Aft Upper Rib Assembly



SAD 11-06-22

## Location

## Loc Qty

## Loc Code

WA

2

69519

2

WA006

3

69157

3

1

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

Work Order ID: 71068

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350 )

Start Date: 6/21/2011

Required Date: 6/30/2011

Start Qty: 1.00

Required Qty: 1.00

D4034-043

Manufactured No

100 Each

4.0000

1

1



Fwd Upper Rib Assembly



SAD 11-00-22

Location

Loc Qty

Loc Code

WA

1

68414

1

WA006

3

70241

3

D2581

Manufactured No

100 Each

66.0000

2

2



Mounting Bracket



SAD 11-06-22

Location

Loc Qty

Loc Code

WA

66

68964

4

69258

28

69739

34

D3913-15

Manufactured No

100 Each

13.0000

1

1



Wide Handle Plate



SAD 11-06-22

Location

Loc Qty

Loc Code

WA

8

69158

4

69647

4

WA005

5

69012

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 4

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Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350 )

Start Date: 6/21/2011

Required Date: 6/30/2011

Start Qty: 1.00

Required Qty: 1.00

D4016-1 Manufactured No

100 Each

31.0000

3

3



Hinge Half, Base



SAD 11-06-22

Location

Loc Qty

Loc Code

WA

31

66418

0

68426

13

70342

18

③

D4020-3 Manufactured No

100 Each

1.0000

1

1



Mesh (350 Basket Short, Base)



11.06.23

Location

Loc Qty

Loc Code

WA

1

67097

1

①

D4020-11 Manufactured No

100 Each

10.0000

2

2



End Mesh, Basket



11.06.23

Location

Loc Qty

Loc Code

WA

10

68547

4

69648

6

②

D4021-1 Manufactured No

100 Each

51.0000

3

3



Handle Plate



SAD 11-06-22

Location

Loc Qty

Loc Code

WA

51

69518

14

69777

37

③

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Shop Packet Print

Page 4

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350 )

Start Date: 6/21/2011

Required Date: 6/30/2011

Start Qty: 1.00

Required Qty: 1.00

D2931  
Bumper  
Manufactured No

150 Each

644.0000

2 2



SB 11/06/28

Location

Loc Qty

Loc Code

ST504

644

46064

644

D4017-041  
Blanking Plate  
Manufactured No

150 Each

24.0000

2 2



SB 11/06/28

Location

Loc Qty

Loc Code

GA

22

70349

22

WA005

2

67008

2

AN3-10A  
Bolt  
Purchased No

150 Each

176.0000

6 6



SB 11/06/28

Location

Loc Qty

Loc Code

ST351

176

117313

42

117795

134

AN960JD8  
Washer  
NAS1149DN832J Purchased No

150 Each

0.0000

2 2



117316

2 SB 11/06/28

W/O:		WORK ORDER CHANGES					
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Required Date: 6/30/2011

Start Qty: 1.00

Required Qty: 1.00

MS20600-AD4W3

Purchased

No

150

Each

939.0000

2

2



Cherry Rivets



SB 11/06/28

Location

Loc Qty

Loc Code

ST321

806

111636

118

117505

500

117601

188

WA018

133

107939

133

2

MS21042L3

Purchased

No

150

Each

2,049.0000

6

6



Nut



SB 11/06/28

Location

Loc Qty

Loc Code

ST300

2049

116549

349

117441

800

117601

400

117885

500

6

NAS1149F0332P

Purchased

No

150

Each

210.0000

12

12



WASHER



SB 11/06/28

Location

Loc Qty

Loc Code

ST275

210

117735

200

17317

10

12

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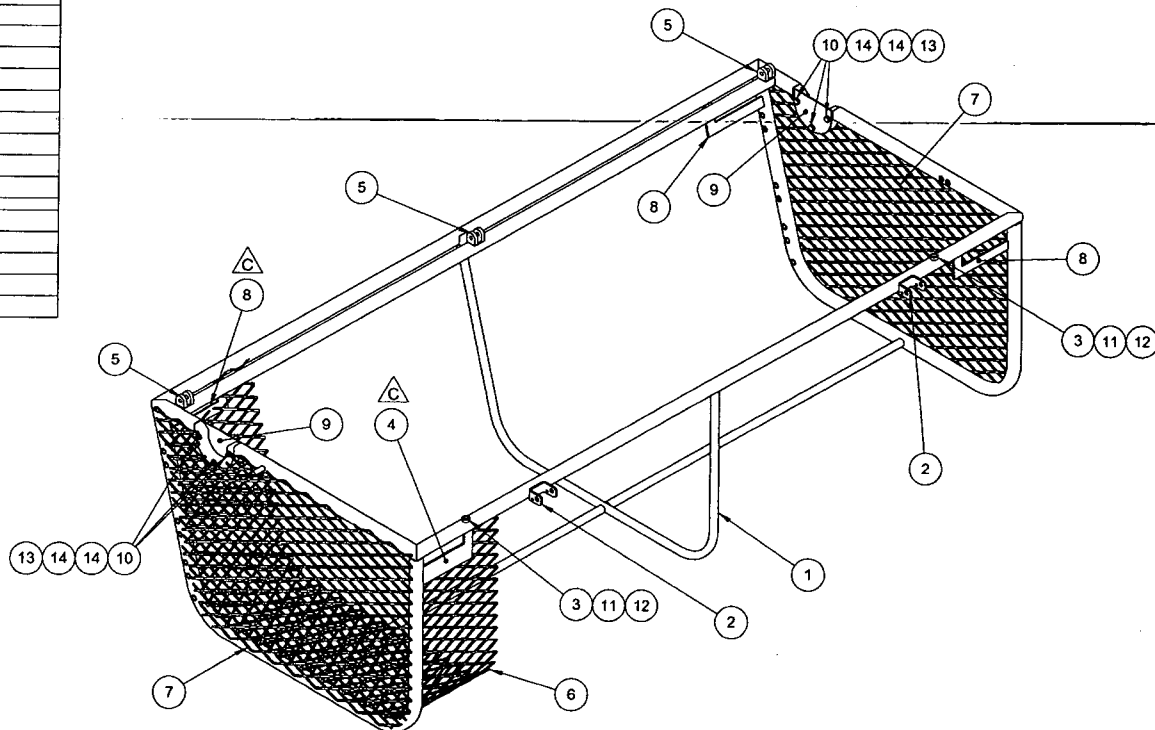
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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ITEM	QTY -041	P/N	DESCRIPTION
	X	D4017-041	SHORT BASKET BASE ASSY (350)
1	1	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
2	2	D2581	MOUNTING BRACKET
3	2	D2931	BUMPER
4	1	D3913-15	WIDE HANDLE PLATE
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-3	MESH (350 BASKET SHORT BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 71068

*RD 11-06-21*

**D4017-041 SHORT BASKET BASE ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

ECN 10-596  
**RELEASED**  
10.08.12

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 28.8 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

C	ITEM #4 NOW INSTALLED OUTBOARD (C4-1, C5-1, B5-2 AND D6-2). REASON: ELIMINATE INTERFERENCE PREVENTING INSTALLATION OF RECEIVER ASSEMBLIES.	MB	10.07.23
B	QTY 1 D4021-1 REPLACED WITH QTY 1 D3913-15; AN3-10A BOLT WAS AN3C10A; NAS1149F0332P WASHER WAS NAS1149C0332R; SECTION F-F UPDATED (D6-2); ITEMS RENUMBERED; DETAIL D UPDATED (A4-3)	JPH	10.03.25
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED	JPH		
MFG. APPR.	JPH		
APPROVED	JPH		
DE APPR.	JPH		
DATE	10.07.23		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D4017</b> TITLE <b>SHORT BASKET BASE ASSY (350)</b> SCALE <b>NTS</b> <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

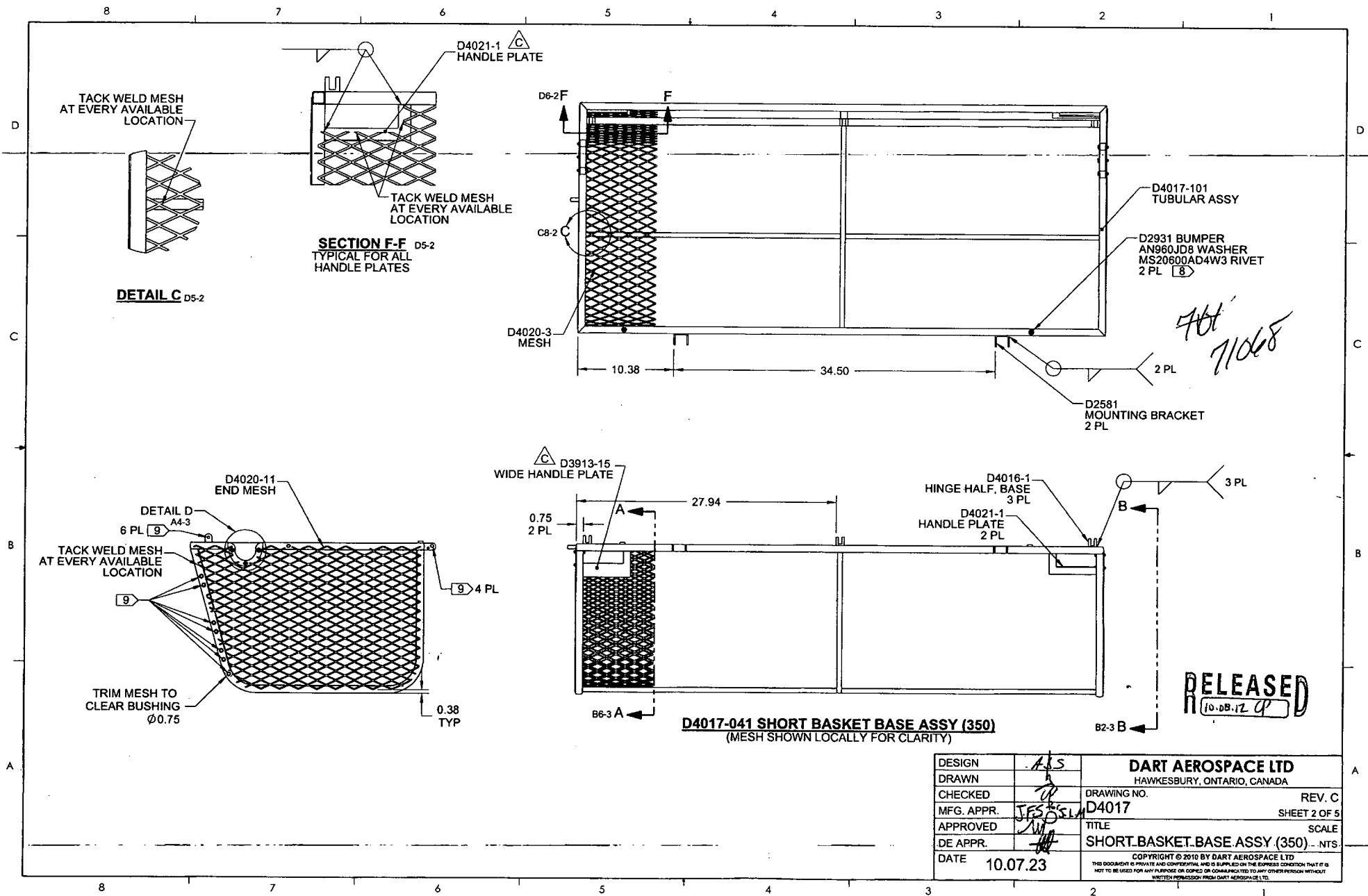
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

D

D

C

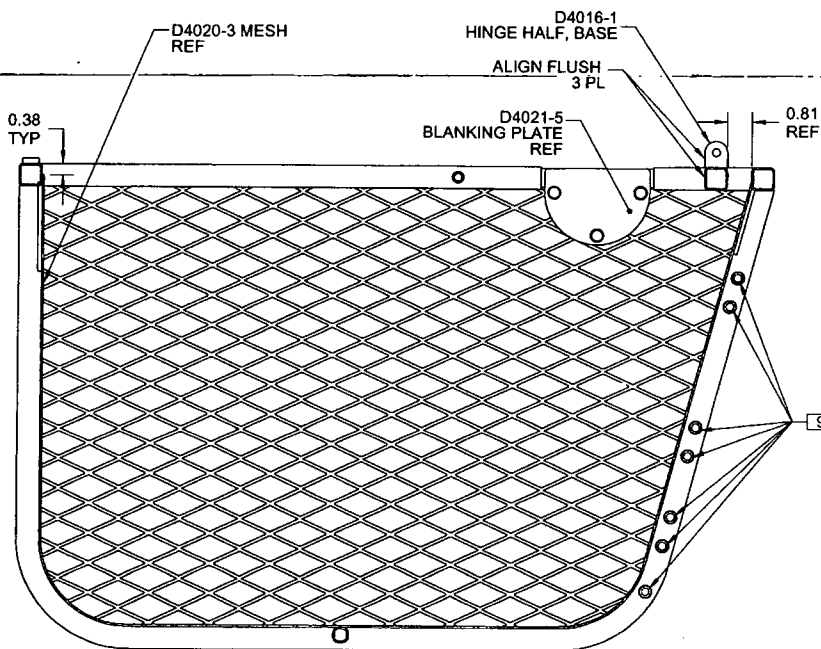
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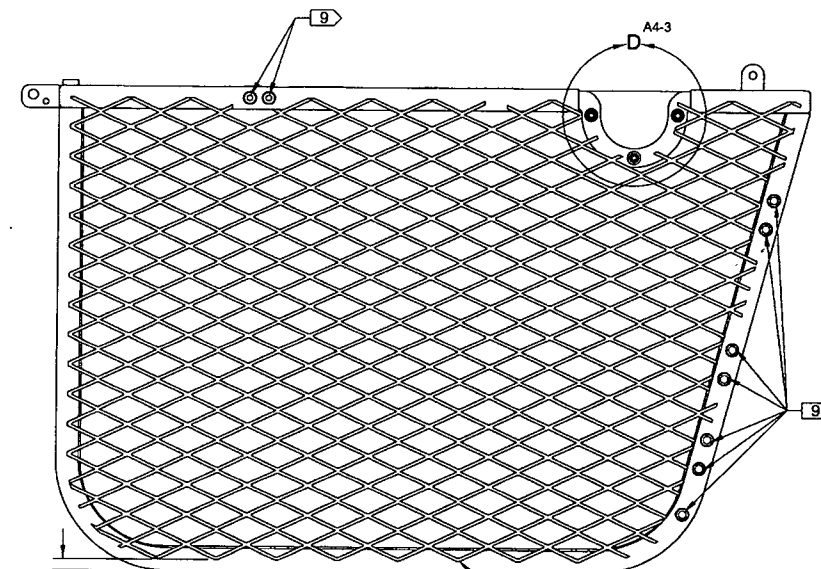
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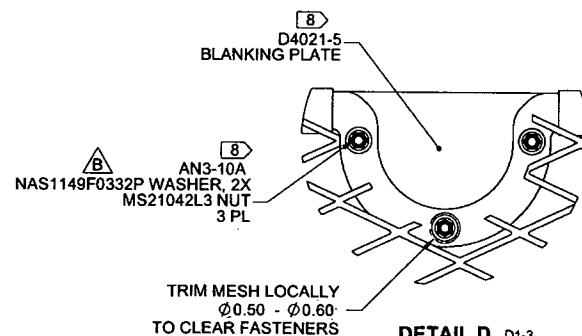
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**SECTION A-A** A5-2



**SECTION B-B** A2-2



**DETAIL D** D1-3 88-2

71068

**RELEASED**  
10.08.12

DESIGN	A15	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JFS	D4017	SHEET 3 OF 5
APPROVED	MA	TITLE	SCALE
DE APPR.	MA	SHORT-BASKET-BASE ASSY (350) -NTS	
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

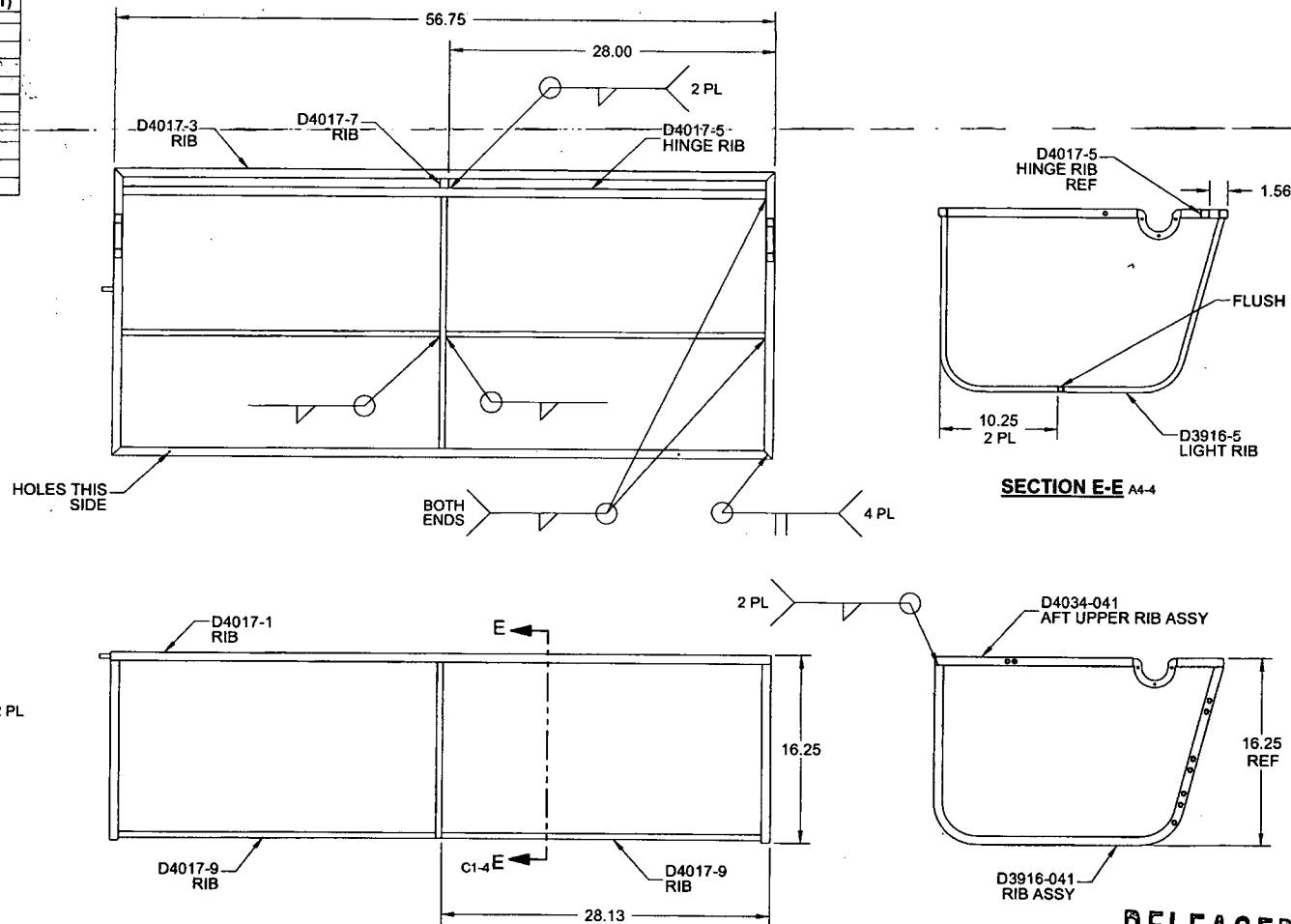
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	QTY -101	P/N	DESCRIPTION
	X	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
1	1	D4017-1	RIB
2	1	D4017-3	RIB
3	1	D4017-5	HINGE RIB
4	1	D4017-7	RIB
5	2	D4017-9	RIB
6	2	D3916-041	RIB ASSY
7	1	D3916-5	LIGHT RIB
8	1	D4034-041	AFT UPPER RIB ASSY
9	1	D4034-043	FWD UPPER RIB ASSY



- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 15.26 lbs
  - 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D4017-101
  - 9) WELD PER DART QSI 004

8 D4017-101 TUBULAR ASSY (350 SHORT BASKET)

DESIGN	ALS	DART AEROSPACE LTD	REV. C
DRAWN	UP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	STK	DRAWING NO. D4017	SHEET 4 OF 5
MFG. APPR.	STK	TITLE	SCALE
APPROVED	JM	SHORT BASKET-BASE ASSY (350)	NTS
DE APPR.	#	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
DATE	10.07.23	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED  
10-08-12 CP

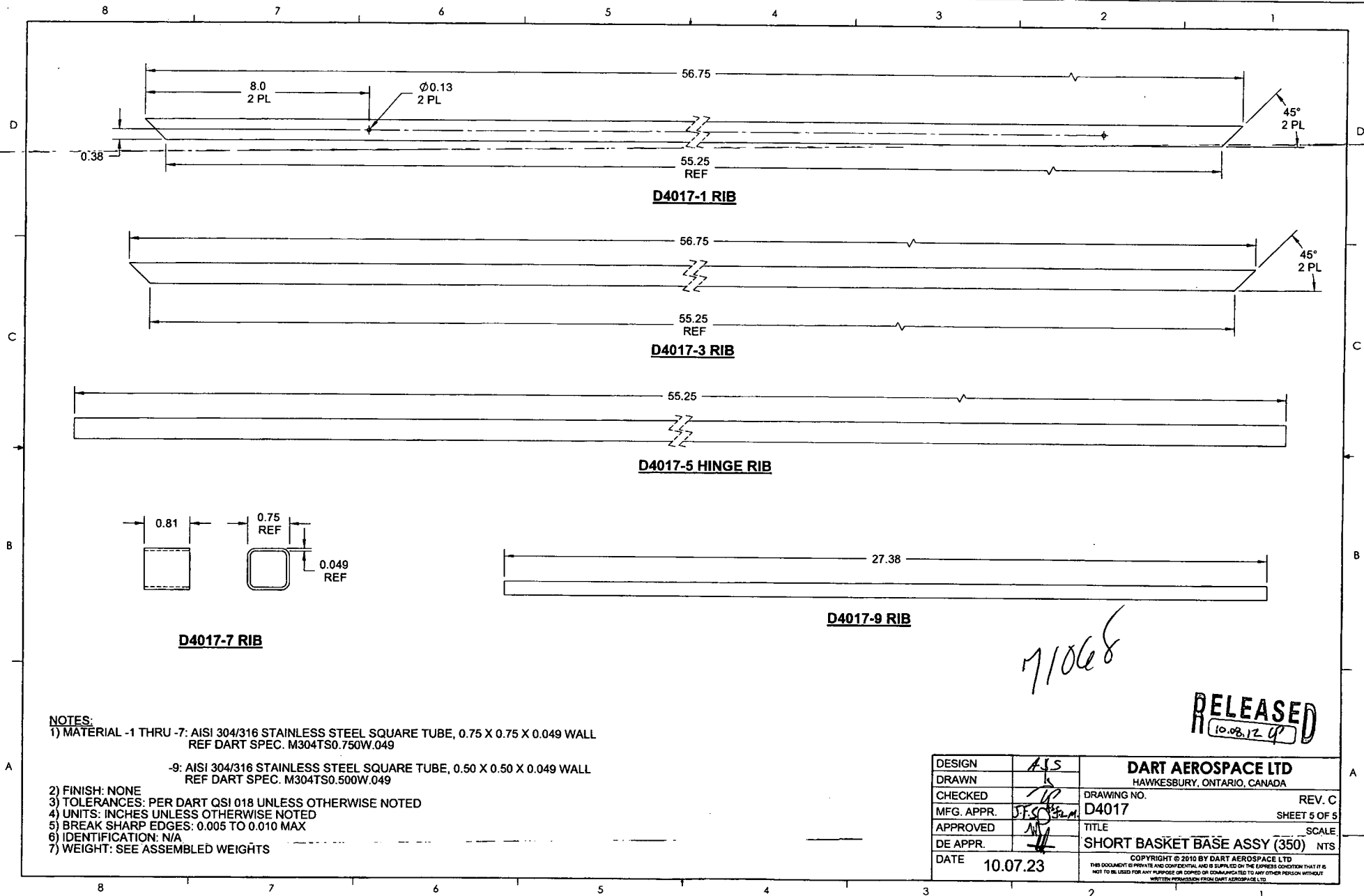
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries